

REFERENCE ONLY

| | | |
|---|---------------------|--------|
| DART AEROSPACE LTD | Work Order: | 22492 |
| Description: Bearpaw Kit (19" x 16") | Part Number: | K10007 |
| Dwg: D2435 Rev. E1; DSK086-3 Rev. A | Qty: | 20 |
| Page 1 of 1 | | |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|------|-------------------------------|--|---------------|-------------|-------------|-------|---|-----------|----------------|--------|---|-------|--------------|--------|---|-------|---------|--------|---|-------|-------|--------|---|-------|--------|---------|---|---------|------|--------|---|---------|------|--------|----|------------|--------|--------|---|-----------|-------------|--------|---|-----------|-------|--------|---|-------------------------------|--|--|--------------|----------|----|
| 1 | DC | Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required | PH | 05.02.21 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | DC | Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately) | UK13 PH DH | 05.04.05 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | GA | Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: M15926 | gml | 05/03/09 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | MV | Inspect material for defects or damage prior to machining | gml | 05/03/09 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5 | MV | Machine as per Folio D2435 and Dwg D2435 Identify as D2435 | SP | 05/03/18 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6 | QC2 | Inspect parts as they come of the CNC machine | SP | 05/03/18 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7 | MV | Deburr | SP | 05/03/18 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | QC8 & 5 | Second inspection | CL | 05.03.28 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 9 | KP | Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B21846</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B22492</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B21586</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B21587A</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M14526</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M15993</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M16020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table> | Qty | Part Number | Description | Batch | 4 | D2182B050 | Rubber Cushion | B21185 | 8 | D2274 | Radius Block | B21846 | 2 | D2435 | Bearpaw | B22492 | 4 | D2438 | Clamp | B21586 | 8 | D2529 | Washer | B21587A | 8 | AN4-15A | Bolt | M15321 | 8 | AN4-17A | Bolt | M14526 | 16 | AN960JD416 | Washer | M15993 | 8 | MS21042L4 | Nut (or -4) | M15020 | 2 | QS200M44S | Clamp | M16020 | 1 | Paperwork package from Step 2 | | | B21872 KP | 05/03/31 | 20 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2182B050 | Rubber Cushion | B21185 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2274 | Radius Block | B21846 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | D2435 | Bearpaw | B22492 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2438 | Clamp | B21586 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2529 | Washer | B21587A | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN4-15A | Bolt | M15321 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN4-17A | Bolt | M14526 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 16 | AN960JD416 | Washer | M15993 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | MS21042L4 | Nut (or -4) | M15020 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | QS200M44S | Clamp | M16020 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | Paperwork package from Step 2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 10 | QC4 | Inspect Kit for 100% Completeness on the W/O | SB | 05/04/05 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 11 | PK | Identify and pack for shipping as per PPP K10007 | REV. E CL | 05/04/05 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 12 | AC | Cost / part 155.06 | 545 | 05.04.06 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 13 | DC | Close W/O 154.59 Inspect Level 21 | PH | 05.04.12 | 20 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---|------------|----------|
| A | 99.12.17 | K10007 created for Bear paw kit (MPP 2000) | EC | |
| B | 01.03.21 | Added OH-58 paperwork (MPP 2092) | EC | |
| C | 01.11.08 | Revised Step 3 and Added Level 21 | SM | |
| D | 03.03.26 | Reformat; Incorporated D2435 | KJ/RF | |
| E | 04.02.17 | Blank size changed, tolerance added to Step 3 | KJ/JLM | |

DELEASER